

Work Order ID 63990

Tuesday, November 23, 2010 9:24:13 AM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 11/22/2010 Start Qty: 200.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-23 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00



SHEAR

Shear

Memo

0.00

ant 10/11/25

220

0

Shear

blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 9 pieces

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

M.A 10/11/30

220

0

HAAS CNC vertical machine #1

Machine as per folio D2274

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

M.A 10/11/30

220

0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

s A 10/12/07

220

Ø

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Tumble ☐ Deburr any rough edges after tumbling

13 10-12-3

220

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=) 10/12/03

220

Ø

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Page 3

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Start Date: 11/22/2010 Start Qty: 200.00

Required Date: 11/30/2010 Req'd Qty: 200.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

220 10-12-3

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

10/12/3 2208

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/07

ME
10-12-03

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, November 23, 2010 9:24:17 AM

Page 1

Work Order ID: 63990



Parent Item: D2274

Parent Item Name: Radius Block

Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H□00.05.18□Added inspection level 8□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	54.1243	0.0916	19.28421			



6061-T6 Bar .750 x .125

Location

Loc Qty

Loc Code

MAT01

54.1243

→ 113608

49.85

113680

1.4947

113719

2.7796

19.284 on 10/21/25

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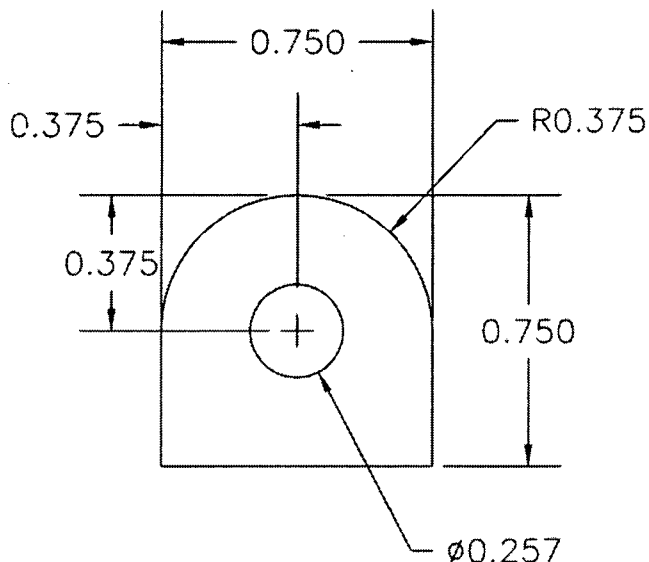
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/19 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

W 63990

B-10-11-23

2 00.05.16
00.05.16

0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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